

Date: Tuesday, 7/1/2008 10:46:37 AM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|---|------------------|------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : EXTRUSION "I" BEAM TUBE 4" | |
| Job Number | : 40150 | | Part Number | : D25001190 | |
| Estimate Number | : 10154 | | Drawing Number | : D2500 UNDER REVIEW <i>OK QP 08-07-01</i> | |
| P.O. Number | : | | Project Number | : N/A | |
| This Issue | : 7/1/2008 | S.O. No. : | Drawing Revision | : G | |
| Prsht Rev. | : NC | | Material | : | |
| First Issue | : / / | Type : SKIDTUBES | Due Date | : 7/30/2008 Qty: 80 Um: Each | |
| Previous Run | : 37544 | | | | |
| Written By | : | | | | |
| Checked & Approved By | : | | | | |
| Comment | : Est: G 02.09.05 Added DSK 066 est H 07.07.06 rev G dwg | | KJ/RF | EC | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|--------------------|
| 1.0 | PG | PURCHASING |
| Comment: PURCHASING Issue P/O: <i>61672</i> <i>C 08/07/02 80</i> a) Extrude as per Dwg D2500 b) Material: 6061-T6 (QQ-A-200/8) <i>OK ASTM B221</i> <i>QP 08-07-01</i> c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 190" long g) Bon L Canada Inc. tool # 897105 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required | | |

| | | |
|-----|------------|----------------------------------|
| 2.0 | D25001190P | Ext'n - 'I' Beam Tube 4" |
|-----|------------|----------------------------------|

| | | |
|--|--|--|
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s) EXTRUSION "I" BEAM TUBE 4" | | |
|--|--|--|

| | | |
|-----|-------------|-------------------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-------------------------------|

| | | |
|---|--|--|
| Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <i>5/28/17</i> <i>HALL 63</i> <i>G 15</i> <i>TOTAL 15</i> <i>(RH)</i> | | |
|---|--|--|

| | | |
|-----|-----|---------------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|---------------------------|

| | | |
|---|--|--|
| Comment: DIMENSIONAL CHECK Inspect dimensions per Dwg D2500 Check Pull test per Dwg D2500 for compliance page attached. <i>5/28/17 (RH)</i> <i>compliant</i> | | |
|---|--|--|

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 10:46:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION 'I' BEAM TUBE 4"

Job Number: 40150

Part Number: D25001190

Job Number:



Seq. #:

Machine Or Operation:

Description :

Check hardness with Webster tester

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: HALL 001 → 63 L.G+15 = TOTAL Am

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|---------------------|-----------------------|---|------------------------|
| DESIGN <i>H</i> | DRAWN BY <i>PS</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>H</i> | APPROVED <i>H</i> | DRAWING NO. D2500 | REV. G SHEET 1 OF 3 |
| DATE 07.04.17 | | TITLE EXTRUSION | SCALE NTS |
| A | 96.03.19 | NEW ISSUE | |
| B | 96.03.24 | CHANGE INTERNAL WEB | |
| C | 96.04.26 | ADD D2500-3 WEB | |
| D | 96.10.07 | ADD MATERIAL PROPERTIES | |
| E | 96.10.24 | CHANGE MATERIAL TEMPER | |
| F | 97.09.29 | CHANGE MAT. TO 6061-T6 | |
| G | 07.04.17 | ADD NOTES 3,5,6 | |

RELEASED
07.06.28 *H*
UNDER REVIEW
08.04.02 *CP*
FOR REV. H

1. MATERIAL: 6061-T6 (QQ-A-200/8 OR ASTM B221) *CP 08.07.01*
 MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
 MINIMUM ELONGATION = 8%
 A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
 ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
 TO ENSURE THAT THE BATCH MEETS THE ABOVE
 MINIMUM MECHANICAL PROPERTIES
2. BREAK ALL SHARP CORNERS 0.010 MAX
3. ALL DIMENSIONS ARE IN INCHES
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG)
 D2500-1 EXTRUSION MANUFACTURED FROM:
 - A) BON L DIE # 897015 -> PREFERRED
 - B) CARADON MIDEAST DIE # PAH-28030
 - C) CARADON MTL DIE # MH-18868
6. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG)
 D2500-3 EXTRUSION MANUFACTURED FROM:
 - A) CARADON INDALEX DIE # MS-18867

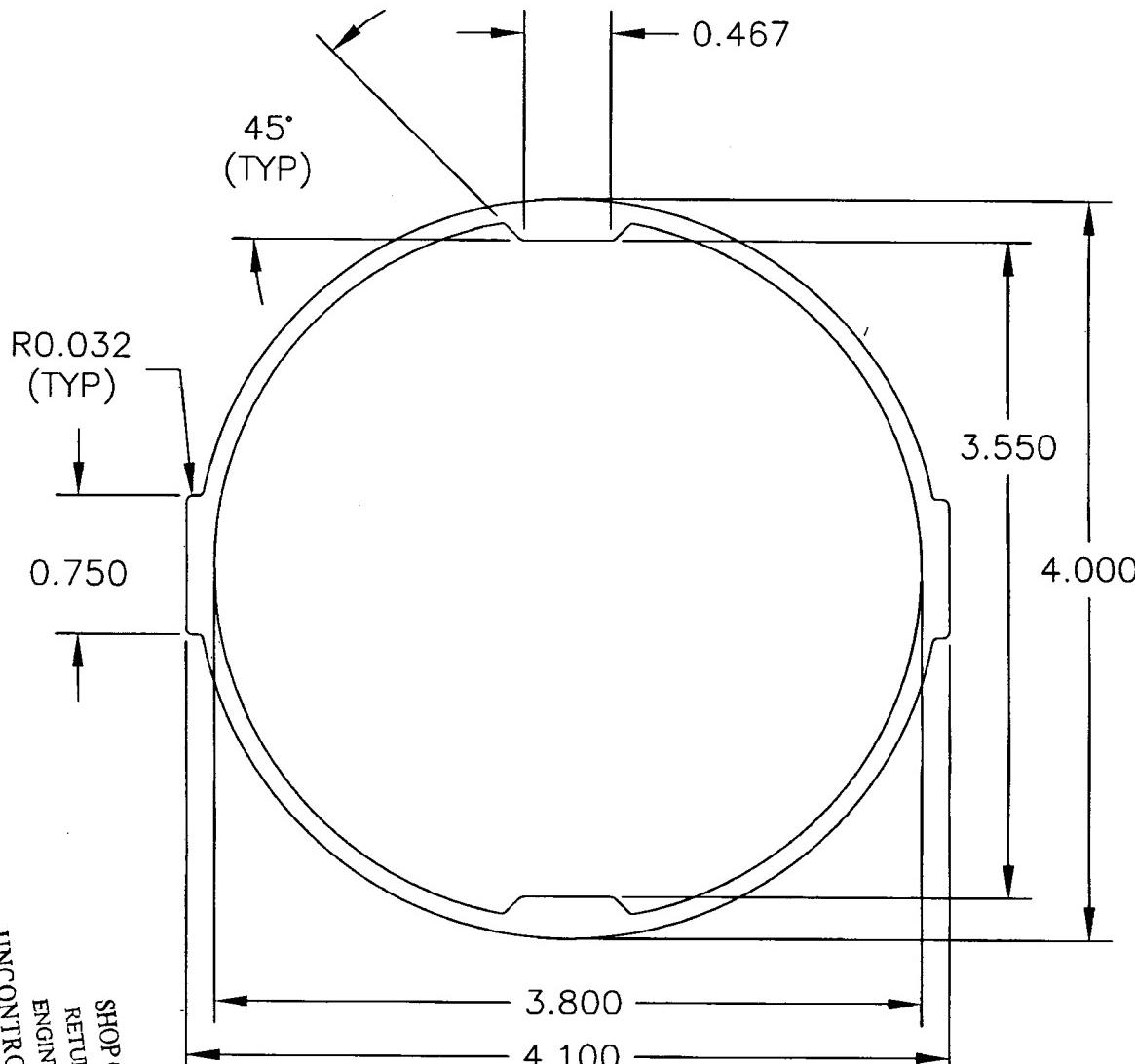
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WITHOUT NOTICE
WORK ORDER
NO. *40150*

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DART

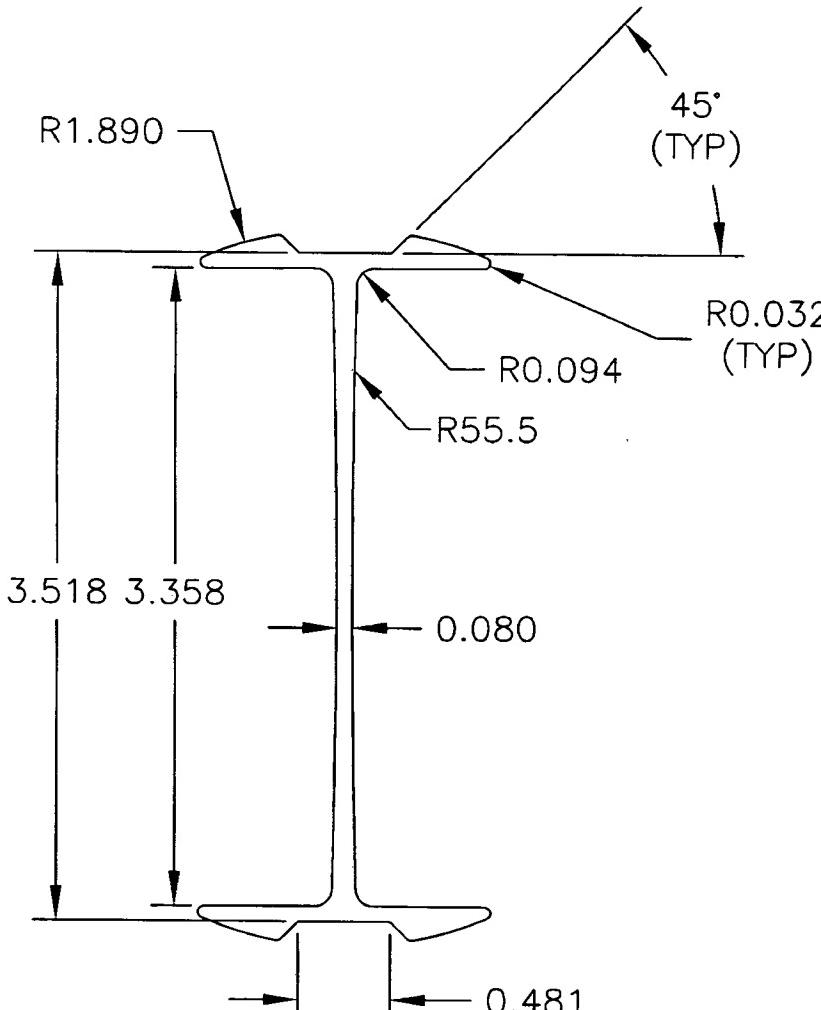
| | | | |
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| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| | RJ | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. G |
| | | D2500 | SHEET 2 OF 3 |
| DATE | | TITLE | SCALE |
| 07.04.17 | | EXTRUSION | 1:1 |

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FOR REV-H**D2500-1**

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NO. W0150

DART

| | | | |
|----------|-----------|-----------------------------|--------------|
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| CHECKED | APPROVED | HAWKESBURY, ONTARIO, CANADA | |
| | | DRAWING NO. | REV. G |
| | | D2500 | SHEET 3 OF 3 |
| DATE | TITLE | | SCALE |
| 07.04.17 | EXTRUSION | | 1:1 |

RELEASED**UNDER REVIEW**08-04-02
F02 REV.H**D2500-3**

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WITHOUT NOTICE
WORK ORDER
NO. 40150

ACCT# 00046024

| SHIP TO | SOLD TO / PURCHASER |
|---|---|
| DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN | DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN |
| PHONE 613-632-5200 | PHONE 613-632-5200 |

INVOICING COMPANY AND LOCATION
 SIGNATURE ALUMINUM CANADA
 1850 CLEMENTS ROAD
 PICKERING ON L1W 3R8

TERMS / FREIGHT
 O / P

| | |
|--|--|
| REFER TO THESE NUMBERS ON ALL CORRESPONDENCE | MANIFEST DATE 07-15-08 |
| | MANIFEST NUMBER 643716 |
| | SALES ORDER NUMBER 33203 |
| CREDIT REP HAMBROOK, PAU 905-508-3250 | SALES REP |
| FIELD SALES REP Kutter A 450-435-6551 | CUST SERVICE REP Burton D 905-427-2227 |

| ITEM NO. | ORIGINAL ORDER QUANTITY | UNIT | PREVIOUS SHIPPED QUANTITY | MFG. PART NUMBER | ALLOY & TEMPER | | FINISH DESCRIPTION | | THIS SHIPMENT | | | UNIT | QUANTITY DUE | | |
|----------|-------------------------|---------|---------------------------|-----------------------------|-------------------------------------|--|---|--|---------------|-------------------|----------------------|---------|-------------------------|--|--|
| | | | | CUSTOMER PART NUMBER | LENGTH | | FABRICATION DESCRIPTION | | NBR OF PKGS | GROSS POUNDS | NET QUANTITY | | | | |
| | | | | | CUTTING TOLERANCE | | SHIPPING TOLERANCE | | | | | | | | |
| 01 | 80 | KG M PC | 0 0 0 | DAA-897105-2 D2500-1-190 | 6061 /T6 190" +5/16 " -0 " | | MILL CERTIFICATE OF COMP (+010-010, 0088-0072) | | 3 | 1037 | 1003 376.43 78 | KG M PC | 30 10 2 | | |
| | | | | LOT/TKT DETAIL: | | | 33203010 / 279174 33203010 / 279175 33203010 / 279176 | | 1 1 1 | 425 306 306 | 409 297 297 | PC | 32 PC 23 PC 23 PC | | |
| | | | | | | | | | | | | | 78 | | |

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

| | | | |
|--------|------|----------------------|---------|
| 3 | 1037 | 1003 376.43 78 | KG M PC |
| TOTALS | | | |



**signature
aluminum
CANADA INC.**

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

| Issue Date | Cert No. | Sales Order | Page |
|------------|-----------|-------------|---------|
| 07/15/08 | 179032 | 33203 | 1 |
| Issue P.O. | Issue No. | Item | Date |
| 6672 | 08380474 | 33203010 | 7/15/08 |

| Ship To: | Ship To: |
|--|--|
| DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 | DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 |

| Item No. | Part No. | Item Description | Cust Part |
|---------------|-------------------------------|-------------------|-------------|
| 1.000 | DAA-897105-2 | 190" Mill 6061 T6 | D2500-1-190 |
| Gross Weight | 1037 KGS | | |
| Net Gt | 1,003 KG | 78 PC | 376 M |
| Specification | AMS-QQ-A-200/8 & ASTM B221-06 | | |

| Mechanical Tests: | | Test Data | | | |
|-------------------|-------------------|-----------------|-------------|--------------|-----------------|
| Test No. | Tensile MPA / KSI | Yield MPA / KSI | %Elongation | Conductivity | Bend/Drift HREW |
| 1 | 278.3 / 40.4 | 252.7 / 36.7 | 10.5 | .0 | 94 |

| Chemical Analysis: | | | | | | |
|--------------------|-----|-----|-----|-----|-----|-----|
| SI | FE | CU | MN | MG | CR | ZN |
| .64 | .26 | .27 | .06 | .88 | .06 | .03 |

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc